

Ship 25-26/05

Work Order ID 58962

May 20, 2010 11:53:04 AM



Page 1

Item ID: D3955-3

Accept



Setup Start



Revision ID:

Item Name: Cover Plate

Stop



Start Date: 5/20/10 Start Qty: 3.00



Cust Item ID:

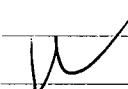
Required Date: 5/25/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:



Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3955	A

100

0.00



Waterjet

Memo

0.00

HB10-5-05

FLOW CNC Waterjet

304.063

1-Cut as per Dwg D3955

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

③

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

HB10-5-05

Quality Control

0.0
0.00

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 58962



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Start Date: 5/20/10 Start Qty: 3.00



Cust Item ID:

Required Date: 5/25/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

8.06525

+3



QC

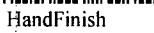
Quality Control

130

Wing Walk as per dwg QSI005 4.4 Batch 114432 0.00

0.00

3 BL 10-5-25.



HandFinish

Hand Finishing

140

QC3- Inspect Part Finish

0.00

M 10/05/25

3 Ø



QC

Quality Control

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
**Set Up/
Run Hours**
**Draw
Number**
**Draw
Rev.**
**Plan
Code**
**Accept
Qty**
**Reject
Qty**
**Reject
Number**
**Insp.
Stamp**

150

Identify as per dwg & Stock Location: 102

0.00

10-5-25 3X SP

Packaging

Memo

0.00

Packaging

160



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/05/26 JH
C21015126

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Picklist Print

May 20, 2010 11:53:03 AM

Page 1

Work Order ID: 58962



Parent Item: D3955-3



Parent Item Name: Cover Plate

Start Date: 5/20/10

Required Date: 5/25/10

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	64.8548	0.3553		1310-5-35	

304/316 Sheet .063



Location	Loc Qty	Loc Code
MAT	64.8548	
111323	0	
114467	64.8548	114467

③

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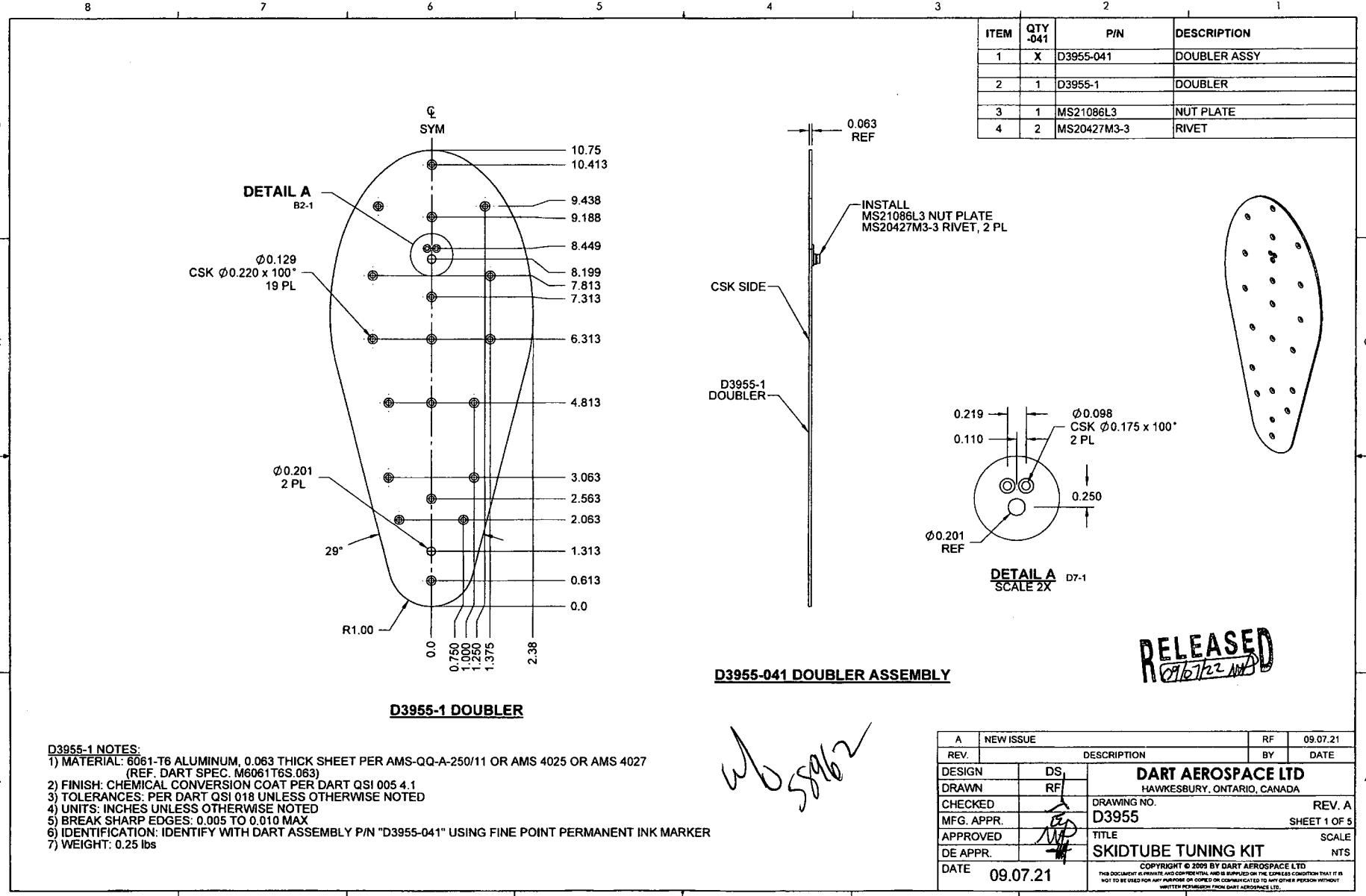
DART AEROSPACE LTD	Work Order:	58962
Description: Cover Plate	Part Number:	D3955-3
Inspection Dwg: D3955 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>RB</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: 10-5-05	Date: 10/05/05		Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	



D3955-1 NOTES:
1) MATERIAL: 6061-T6 ALUMINUM, 0.063 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N "D3955-041" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.25 lbs

D3955-041 DOUBLER ASSEMBLY

RELEASED
09/07/22 MHD

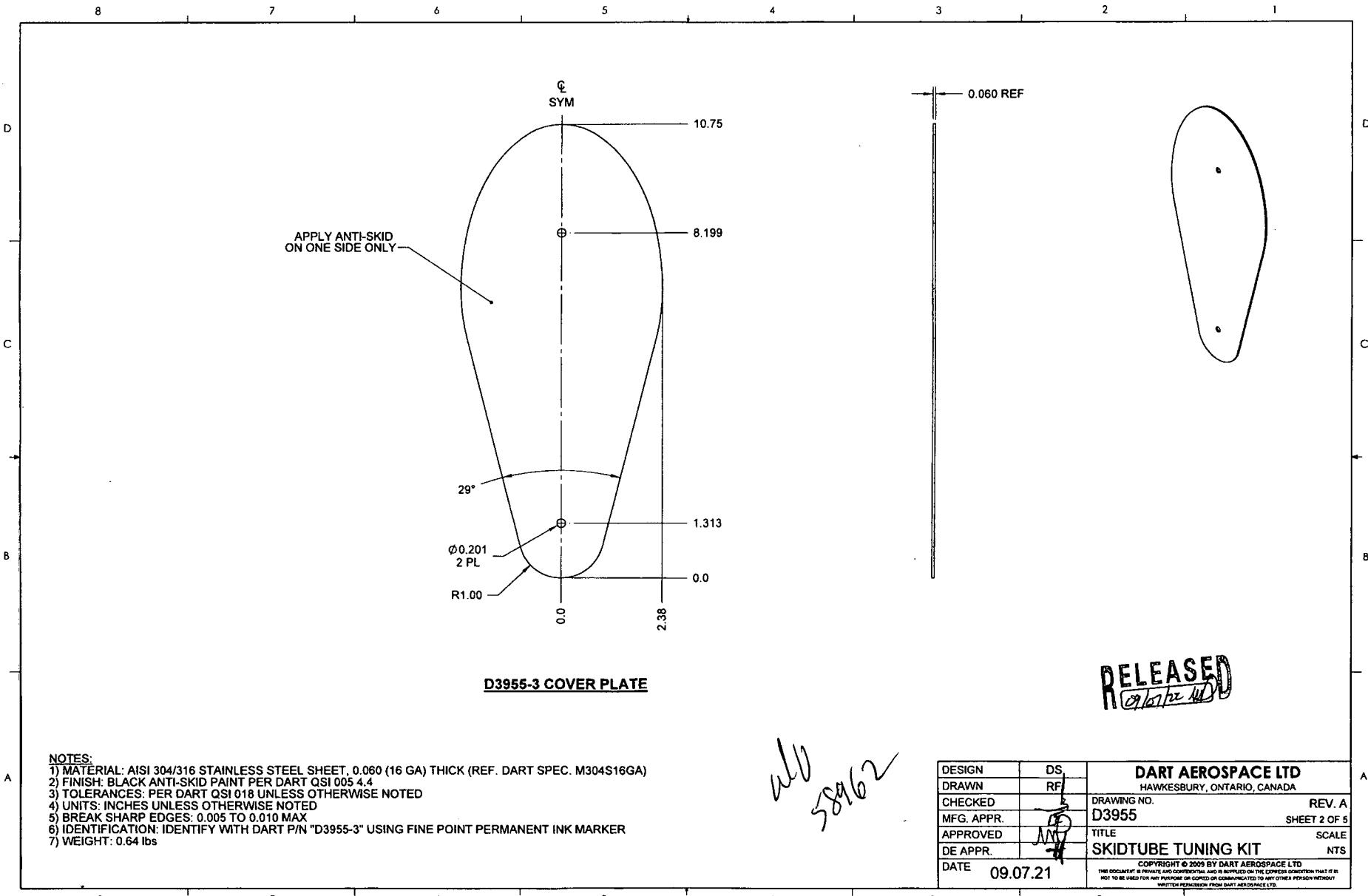
A	NEW ISSUE		RF	09.07.21
REV.	DESCRIPTION		BY	DATE
DESIGN	DS	DART AEROSPACE LTD		
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>✓</i>	DRAWING NO.	REV. A	
MFG. APPR.	<i>ED</i>	D3955	SHEET 1 OF 5	
APPROVED	<i>MW</i>	TITLE	SCALE	
DE APPR.	<i>✓</i>	SKIDTUBE TUNING KIT	NTS	
DATE	09.07.21		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT	

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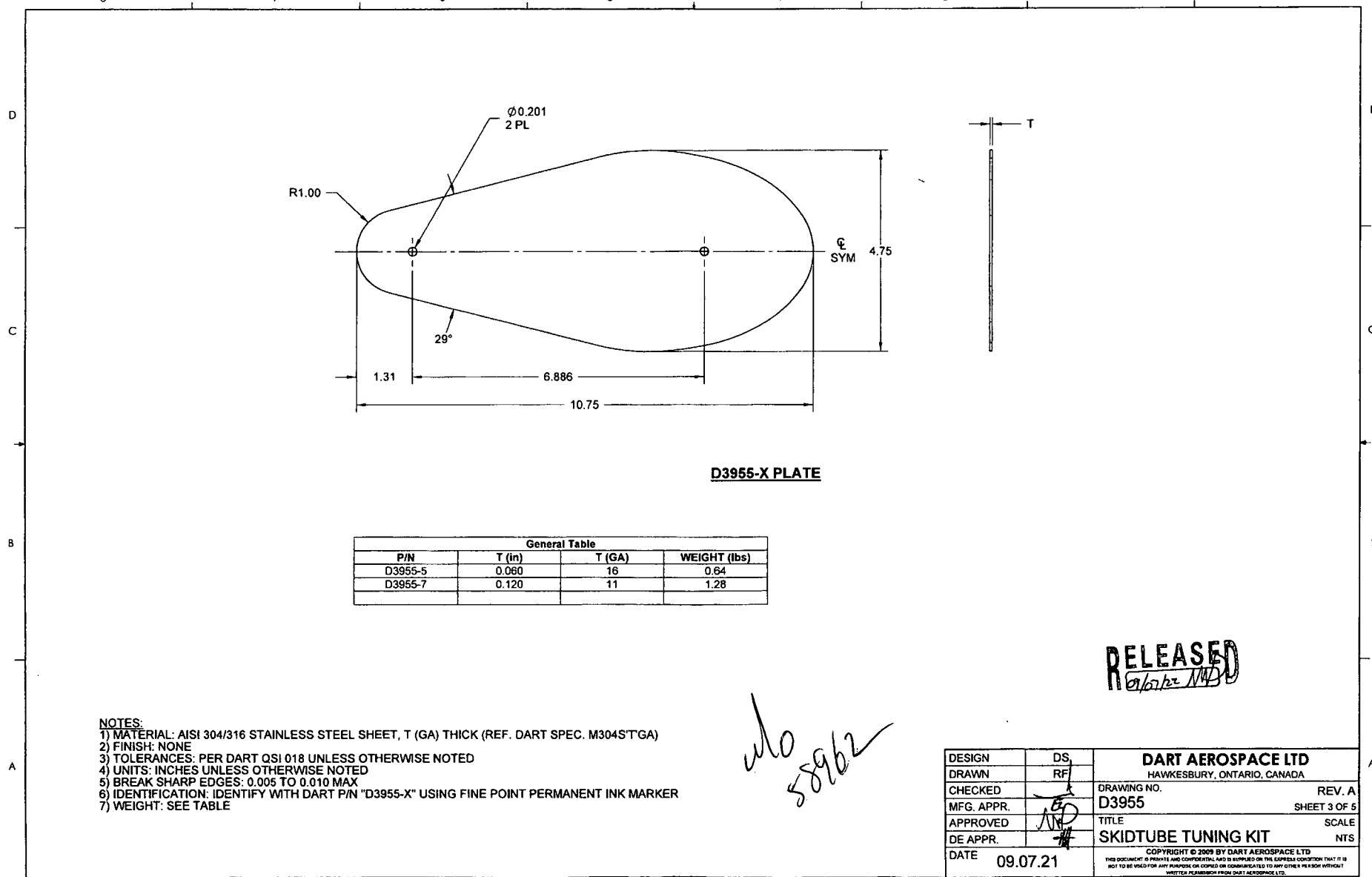
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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

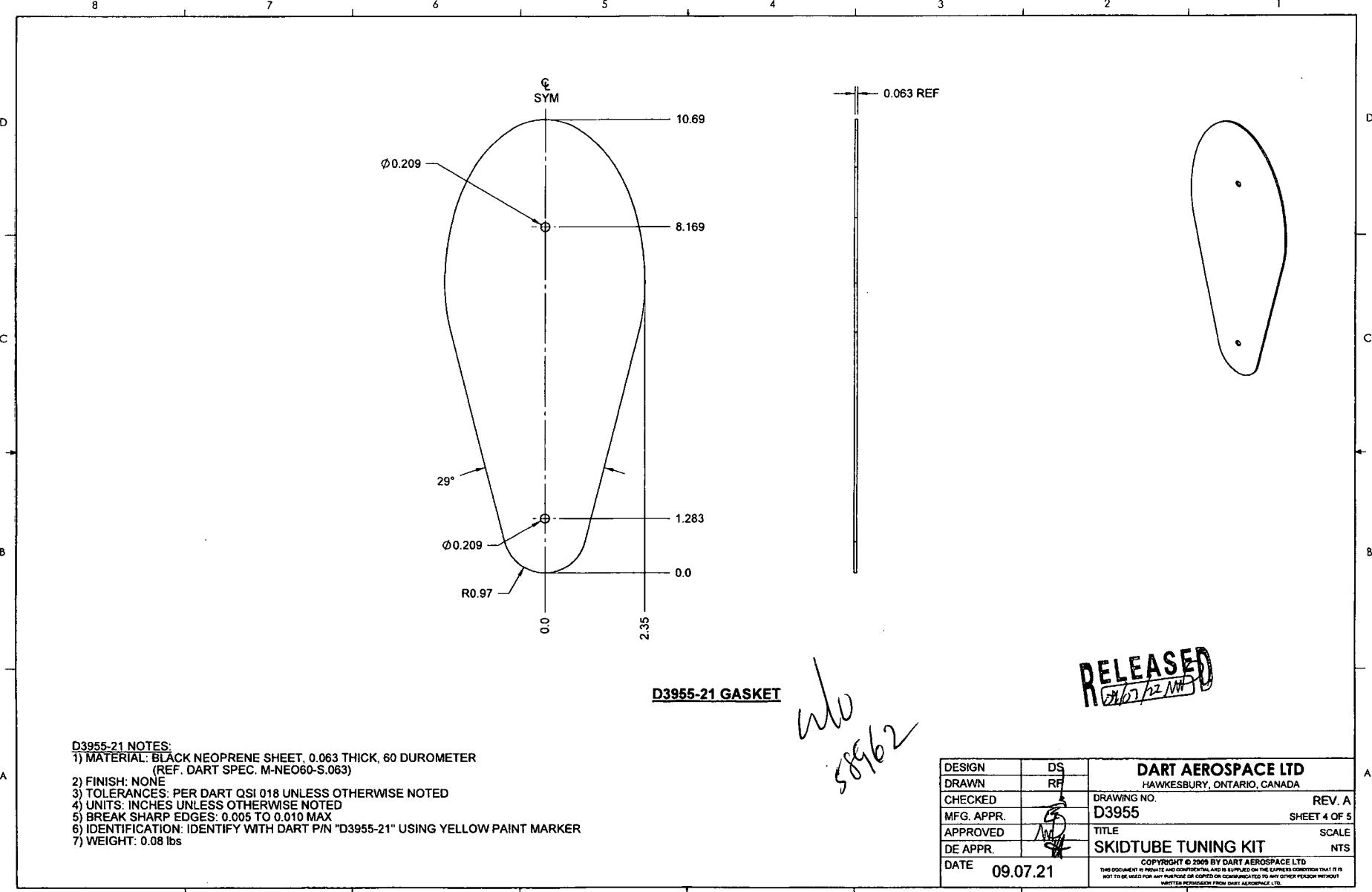
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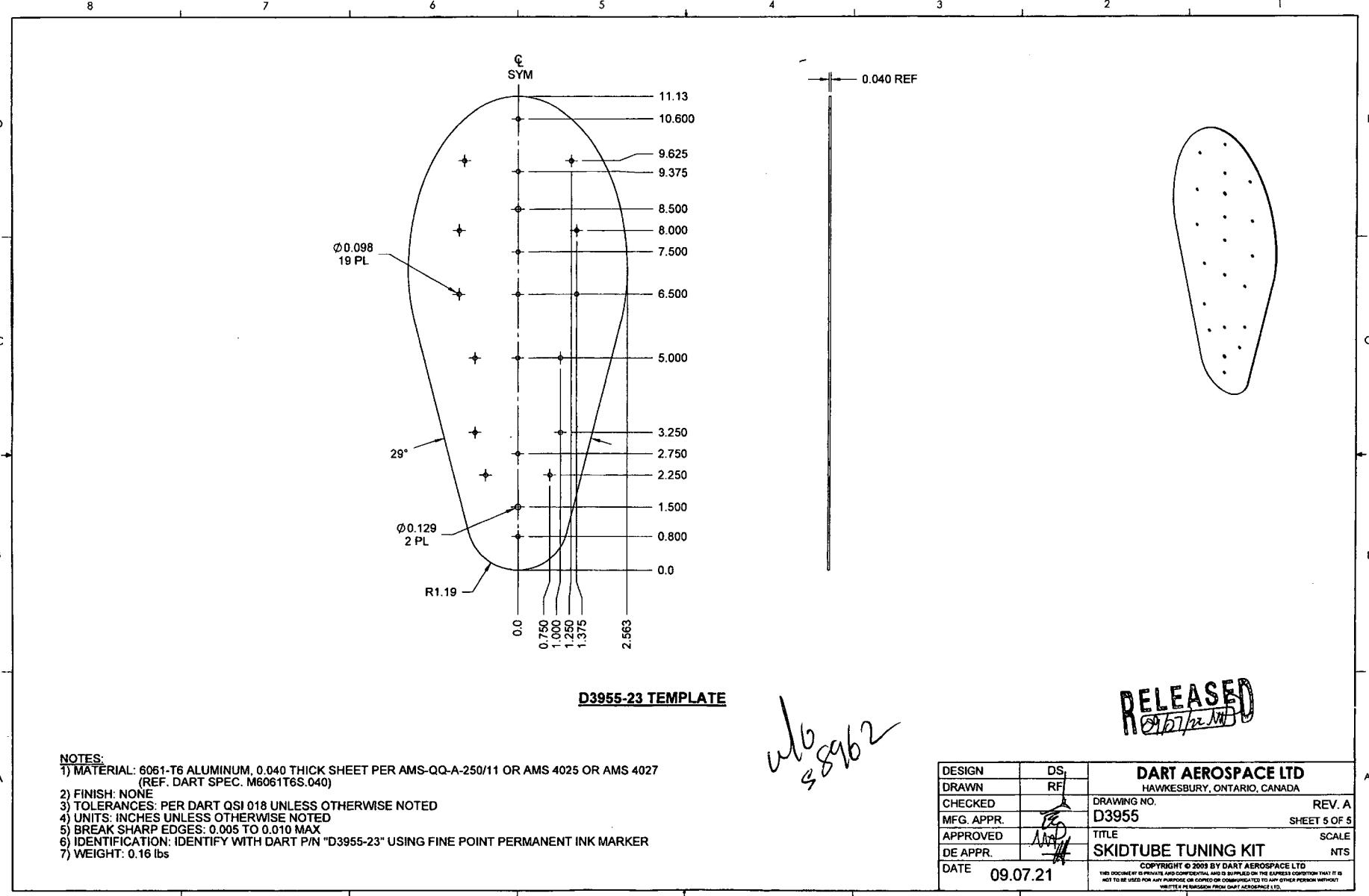
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
		D3955	SHEET 4 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		SKIDTUBE TUNING KIT	NTS
DE APPR.			
DATE	09.07.21	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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